

Date: Thursday, 22/01/2009 7:53:46 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY
Job Number	: 45024		
Estimate Number	: 13479		
P.O. Number	:	Part Number	: PB674300159
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.14
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 43054	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 7 Um: Each
Checked & Approved By	: <u>umf 09-01-22</u>		
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec Est Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: eC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001113	Square Tubing
✓		
Comment:	Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s) Square Tubing batch: <u>B41427</u> <u>umf 09-01-26</u>	
2.0	PB6743001119	End Cap Clevis
Comment:	Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s) End Cap Clevis batch: <u>B23832 x 1</u> , <u>B41478 x 6</u> <u>umf 09-01-26</u>	
3.0	PB6743001117	Hook Plate
Comment:	Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s) Hook Plate batch: <u>B40015 x 2</u> , <u>B23990 x 3</u> , <u>B41865 x 2</u> <u>umf 09-01-26</u>	
4.0	PB6743001115	Tube End Plate
Comment:	Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s) Tube End Plate batch: <u>24087</u> <u>umf 09-01-26</u>	
5.0	PB6743001271	Doubler
Comment:	Qty.: 2.0000 Each(s)/Unit Total: 14.0000 Each(s) Doubler batch: <u>B41498 x 16</u> <u>umf 09-01-26</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W



Comment: Qty.: 0.1575 f(s)/Unit Total: 1.2600 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: 11109397

SP 09.01.27

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

(7)

SP 09.01.28

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.01.28 (7)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/28 (7)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP 09-01-28

(7)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320°
11:00

MD / BR 09-02-05

(7)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/02/05

(7)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total: ⁷8.0000 Each(s)

PB67-43001-267

batch:

41497

SS 09/02/06 (K7)

14.0

PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: ⁷8.0000 Each(s)

Square Sleeve

batch:

41866 x 6 PB43329 x1

SS 09/02/06 (K7)

15.0

BSP43

RIVET



Comment: Qty.: 6.0000 Each(s)/Unit Total: ⁴²48.0000 Each(s)

RIVET

batch:

M109119

SS 09/02/06 (K7)

16.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: ¹⁴16.0000 Each(s)

PIN, QUICK RELEASE

batch:

M18119 x2 M108826 x3 M109031 x7

SS 09/02/06 (K7)

17.0

30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: ¹⁴16.0000 Each(s)

LANYARD

batch:

M17820 x9 M17820 x5

SS 09/02/06 (K7)

18.0

MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: ¹⁴16.0000 Each(s)

SCREW

batch:

M18057

SS 09/02/06 (K7)

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ¹⁴16.0000 Each(s)

Nut

batch:

M109798

SS 09/02/06 (K7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: ²⁸32.0000 Each(s)

WASHER

batch: M18057

SS 09/02/06 (X7)

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

SAD 09-03-02 (7)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/02 (X7)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: corner stock

9/3/2

(76)

SP

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/03

Job Completion



mf 09-03-03

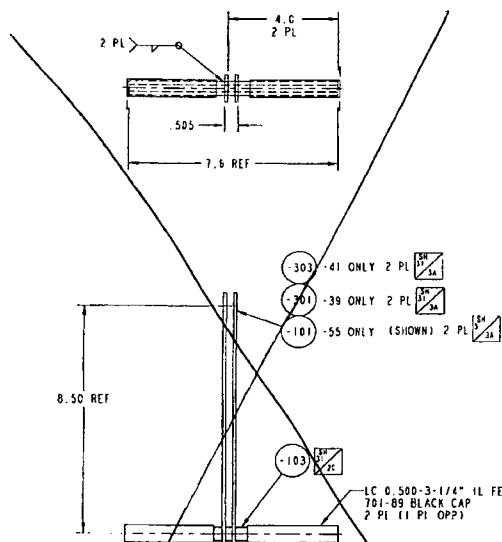
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-59 PAR #: N/A Fault Category: Prod Eng Assy Large NCR: (Yes) No DQA: AD Date: 09/03/03
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: AD Date: 09/03/03

NCR: <u>45024</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09.02.06</u>	<u>21.0</u>	<u>PAD INSTALLED WITHOUT LANYARDS.</u> <u>R.L. Hummer error</u> <u>employee Didn't READ Dwg</u> <u>correctly</u>	<u>09.02.06</u>	<u>REMOVE RIVETS (2) AND</u> <u>INSTALL LANYARDS PER DWG.</u> <u>ADD WASHERS: P/N = AN960-4L</u> <u>P/N = M106389</u>	<u>SAD</u> <u>09-02-06</u>	<u>S</u> <u>09/03/02</u>	<u>09.02.06</u>	<u>S</u> <u>09/03/02</u>

NOTE: Date & initial all entries

RELEASED
4-2-42

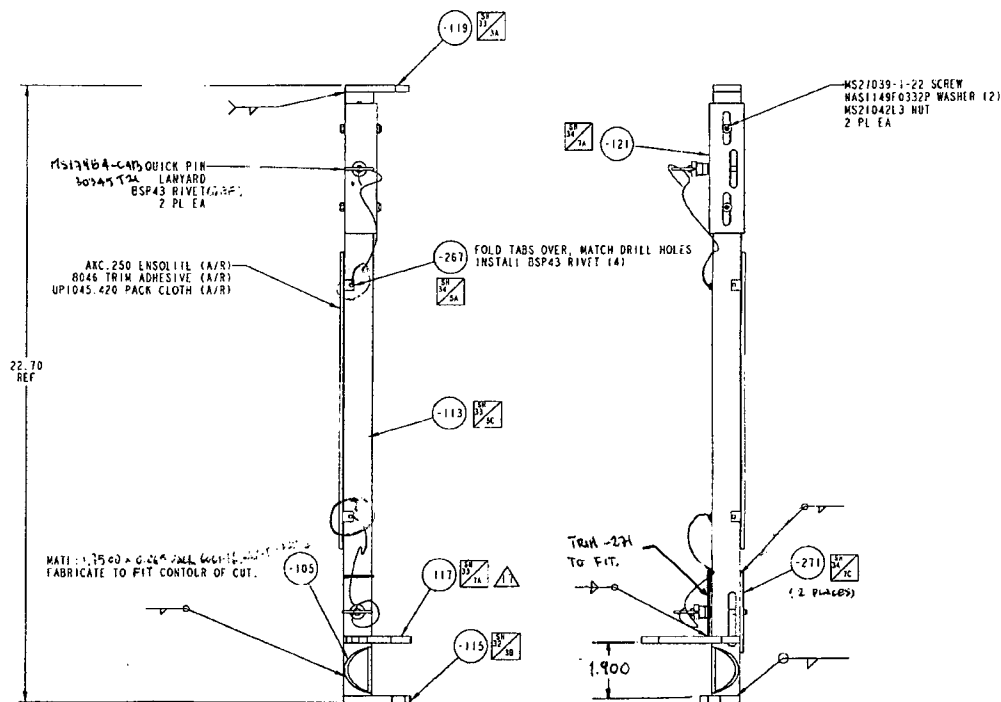


- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY

SUPERSEDED BY D5451-041/-043/-045/-047



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

45024

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75050
STYL CONE TRIST NO DWG NO
D5451-041 B67 43001
SCALE: 01 SHEET 12 OF 45

ORIGINAL